

Shop Monday 14/06

Work Order ID 59735

June 10, 2010 10:27:32 AM



Page 1

Item ID: D119-647-011

Accept



Setup

Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 6/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 6/14/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3034

Rev A1

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D119-647-011

CHG 002

S. Galway

for BG 10/06/10

160



Packaging

Packaging

Pick Kit

0.00

0.00

10-6-11 C to S

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

S. Galway

(af)

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

0.00

Packaging



Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-647-011

Location:

PPP Rev:

B

190



QC21- Final Inspection - Work Order Release

0.00

Quality Control

QC

Memo

0.00

Picklist Print

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Work Order ID: 59735



Parent Item: D119-647-011



Parent Item Name: Bearpaw

Start Date: 6/10/10

Required Date: 6/14/10

Comments: IPP Rev:A New Issue 07-02-02 JLM

Start Qty: 4.00

IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC

IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC

IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

D3034-1



Manufactured

No

170

Each

0.0000

2

8



B59735 10-6-11 \$

Bearpaw

D2182B



Rubber Cushion

Manufactured

No

170

f

315.5812

2.75

11.57895



10-6-11 \$

Location	Loc Qty	Loc Code
ST402A	9.67	
30872	9.67	
ST410	305.9112	
52649	305.9112	

cut to 5.5"per dwg D2182 (D2182B055) {QTY 6}

D2274



Radius Block

Manufactured

No

170

Each

639.0000

12

48



10-6-11 \$

Location	Loc Qty	Loc Code
ST010	639	
57714	146	
57912	273	
59108	220	

D2529



Washer

Manufactured

No

170

Each

614.0000

12

48



10-6-11 \$ 40

Location	Loc Qty	Loc Code
ST017	614	
56184	14	
58568	600	

70
34

Picklist Print

Page 2

June 10, 2010 10:27:30 AM

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Required Date: 6/14/10

Comments: IPP Rev:A New Issue 07-02-02 JLM
IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC
IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC
IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

Start Qty: 4.00

Required Qty: 4.00

D2947	Manufactured	No	170	Each	116.0000	6	24
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10-6-11SF

Clamp

Location	Loc Qty	Loc Code
----------	---------	----------

ST457	116	
55756	116	

AN4-15A



Purchased	No	170	Each	363.0000	12	48
-----------	----	-----	------	----------	----	----



20
10-6-11SF

Bolt

Location	Loc Qty	Loc Code
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ST358	363	
114239	3	
114292	60	
114615	100	
114784	200	

AN960JD416



NAS1149D0463J	Purchased	No	170	Each	18.0000	12	48
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1114576 10-6-11SF

Washer

Location	Loc Qty	Loc Code
----------	---------	----------

ST357	18	
107939	18	

Picklist Print

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Parent Item Name: Bearpaw

Start Date: 6/10/10

Required Date: 6/14/10

Comments: IPP Rev:A New Issue 07-02-02 JLM

Start Qty: 4.00

IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC

IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC

IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

MS21042L4



Purchased

No

170

Each

3,833.000

12

48



10.6.11 SJ (4)

Nut

5/4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	2	
111827	2	
ST300	3831	
113422	68	
114523	755	
114718	1000	48
114784	2000	
9063	8	

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skidtubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-647-011 Bearpaw Installation on model A119 aircraft	15.4 lb 7.00 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	173.2 in 4.40 m	2667 in-lb 30.8 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D119-647-011	BEARPAW INSTALLATION
6	D2182B055	RUBBER CUSHION
12	D2274	RADIUS BLOCK
2	D3034-1	BEARPAW
12	D2529	WASHER
6	D2947	CLAMP
12	AN4-15A	BOLT
12	AN960JD416	WASHERS
12	MS21042L4	NUT (OR MS21042-4)

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32-00-00

Revision: 0

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries